

Date: Wednesday, 9/12/2007 12:13:38 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PANEL	
Job Number	: 34607		Part Number	: D32455	
Estimate Number	: 10873		Drawing Number	: D3245 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 9/12/2007 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 10/5/2007	
Previous Run	: 33837		Qty:	8	
Written By	:		Um:	Each	
Checked & Approved By	:				
Comment	: Est. A 04.07.07 New issue KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S22GA	304/316 .032 Sheet
Comment: Qty.: 0.8442 sf(s)/Unit Total : 6.7536 sf(s) 304/316 .032 Sheet Batch: 10S 262 HB 07-09-18		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3245 Dwg Rev: A HB 07-09-18 Prog Rev: 		
2-Deburr if necessary HB 07-09-18		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-09-18		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK Es 07-09-18		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary Form D3245-5 as per Dwg D3245!identify as D3245-5 SB 07/09/27		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:38 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: PANEL
Job Number: 34607		Part Number: D32455
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5 	INSPECT WORK TO CURRENT STEP  5 08/26 (P 10) <i>carto</i>
7.0	PACKAGING 1 	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>3/9/28 59 (ox) (13)</i>
8.0	QC21 	FINAL INSPECTION/W/O RELEASE  Comment: FINAL INSPECTION/W/O RELEASE <i>10/10/28</i>
Job Completion 		<i>U 8/09/28</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

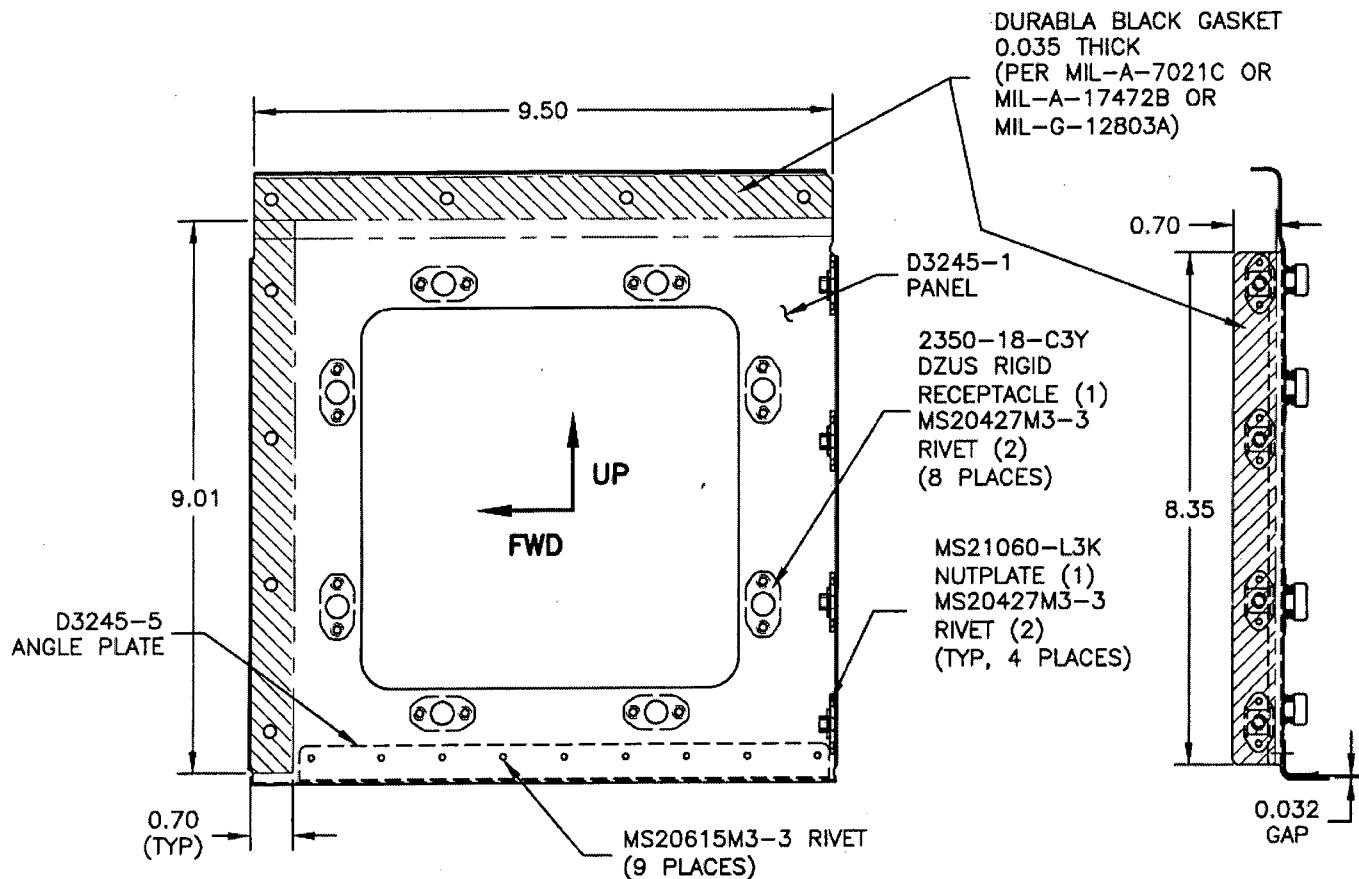
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AA</i>	APPROVED <i>AA</i>	DRAWING NO. D3245	REV. A SHEET 1 OF 6
DATE 04.01.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:3
A	04.01.27	NEW ISSUE	

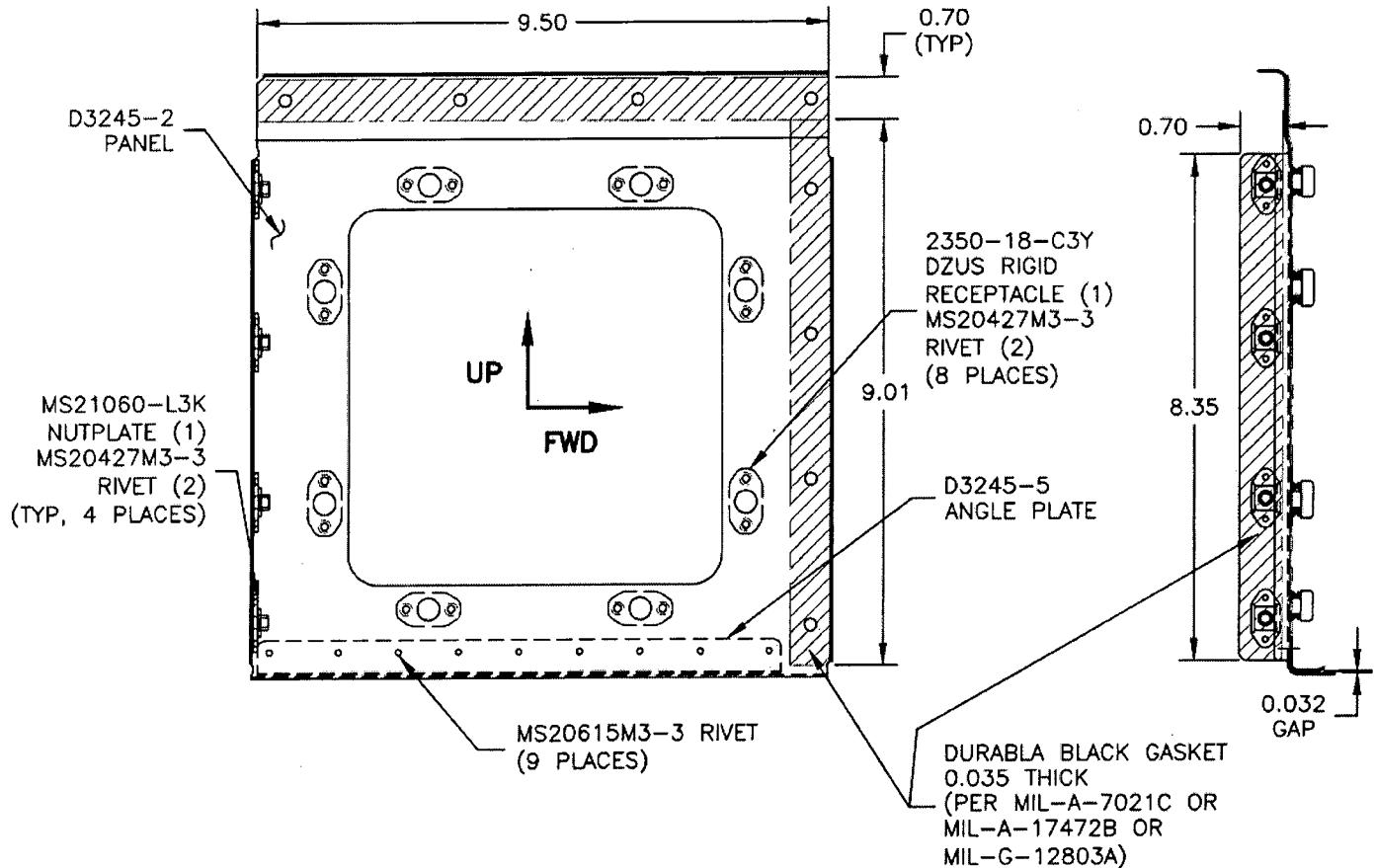
**RELEASED**  
04.04.21 *AA***D3245-041 ACCESS PANEL ASSEMBLY****D3245-041 NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE WITHOUT NOTICE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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NO. *34601*

**DART**COPY ISSUE  
DATE

DESIGN RF	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED A	APPROVED A	DRAWING NO. D3245
DATE 04.01.27		REV. A SHEET 2 OF 6 SCALE 1:3

**RELEASED**  
04.04.21**D3245-042 ACCESS PANEL ASSEMBLY****D3245-042 NOTES:**

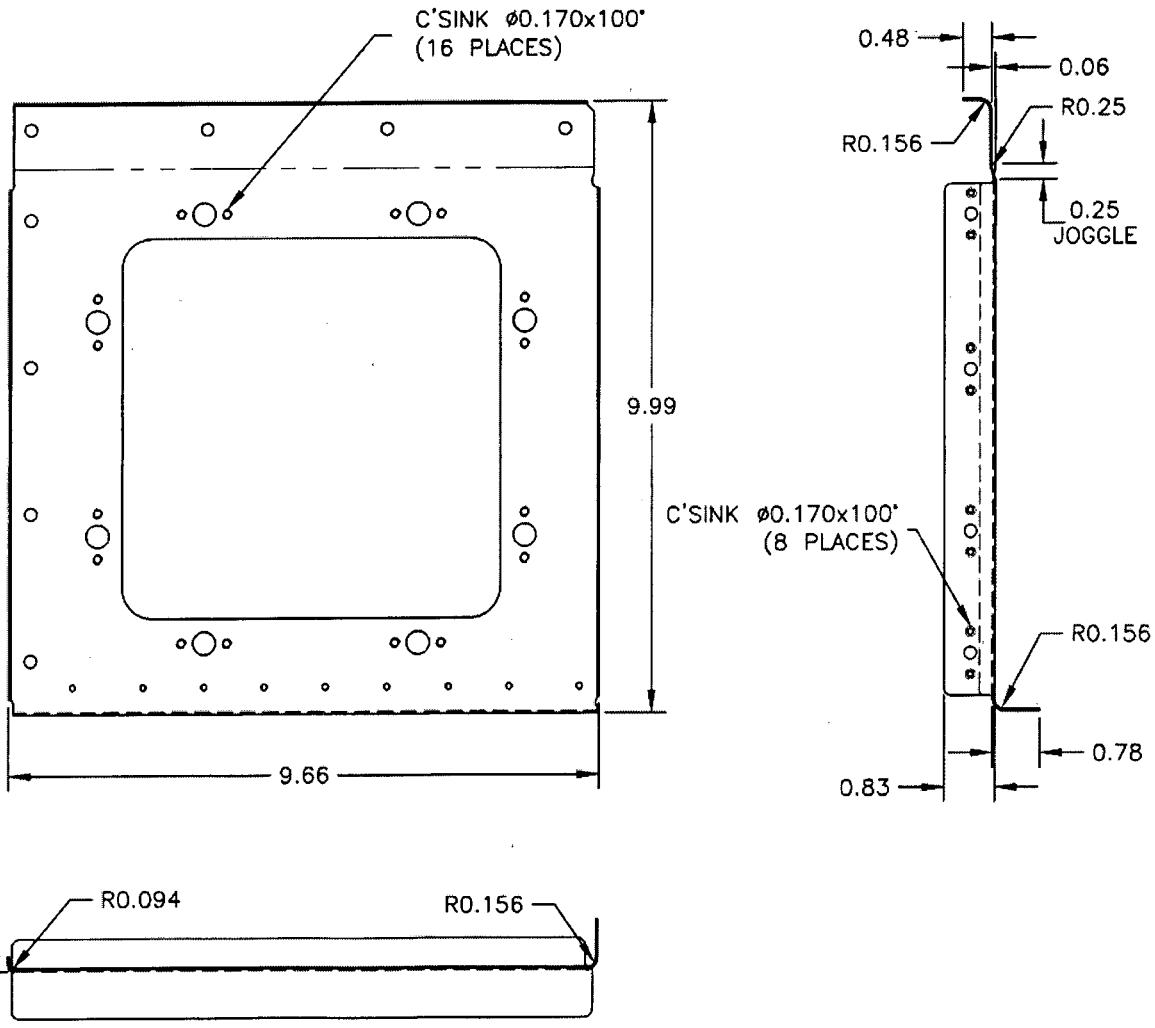
- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE SUBJECT TO AMENDMENT IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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NO. *346021*



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CHECKED	APPROVED	DRAWING NO. D3245 REV. A
DATE		SHEET 3 OF 6
04.01.27		SCALE 1:3 TITLE ACCESS PANEL ASSEMBLY

RELEASED  
04.04.21



D3245-1 PANEL BEND DETAIL SHOWN  
BEND D3245-2 PANEL OPPOSITE

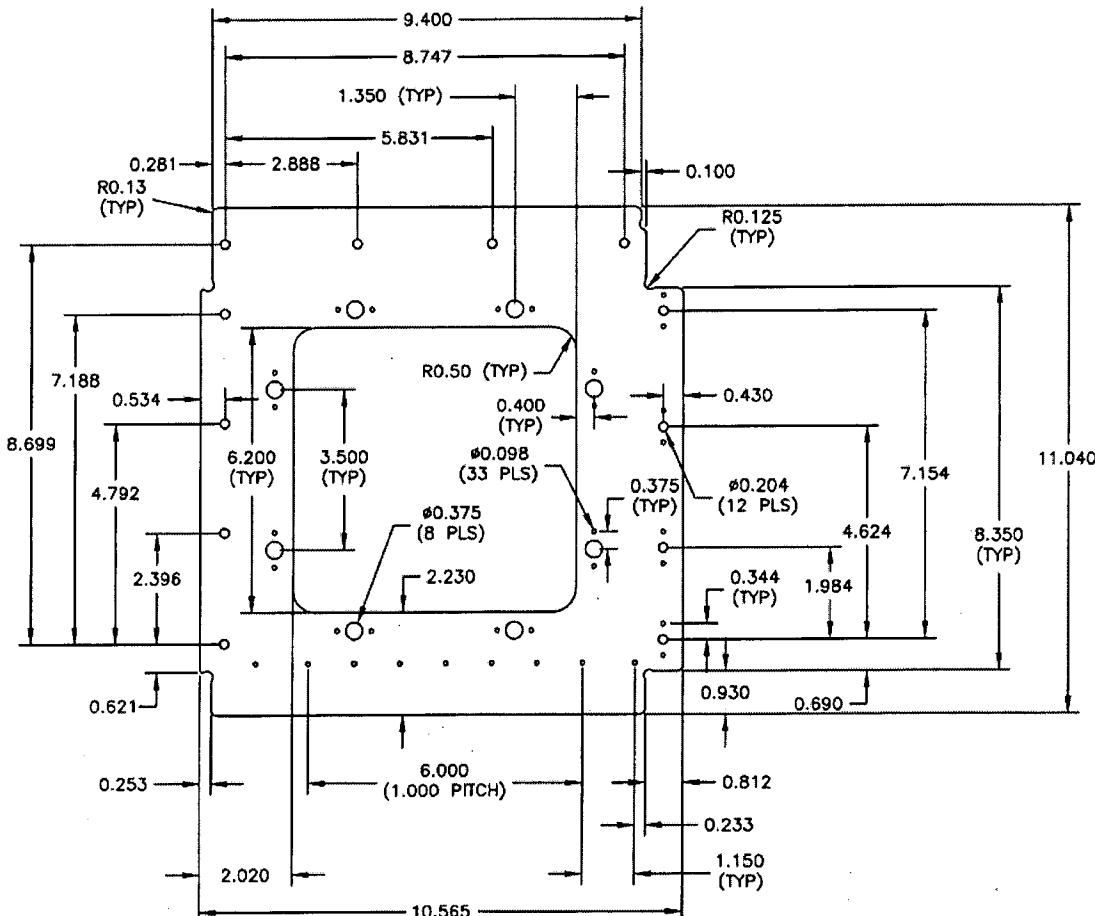
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WORK ORDER  
NO. 346007

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DESIGN RF	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3245
DATE 04.01.27		REV. A SHEET 4 OF 6 TITLE ACCESS PANEL ASSEMBLY SCALE 1:4

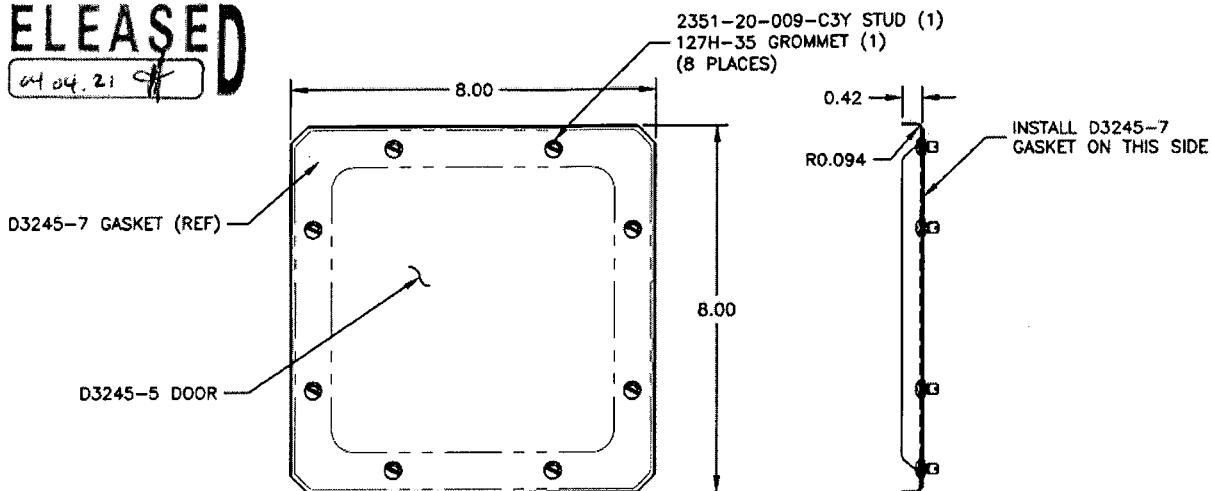
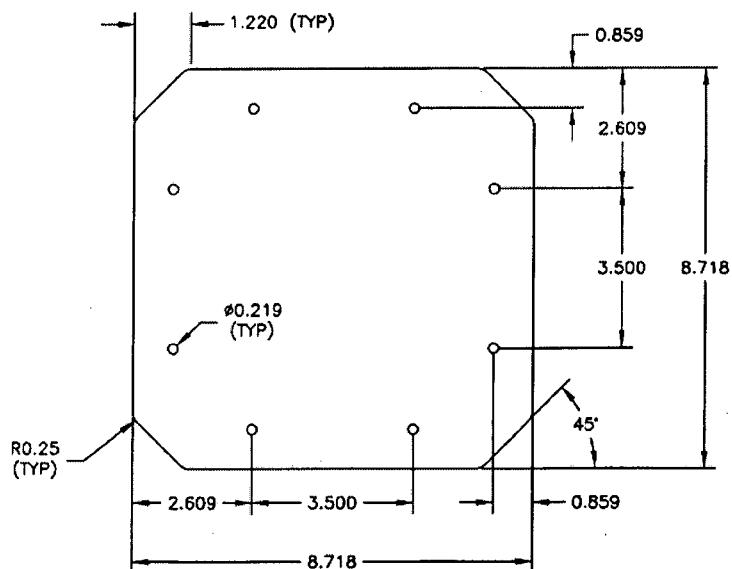
**RELEASED**04.04.21 *[initials]***D3245-1/-2 PANEL FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) ALL DIMESIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
NO. *34601*

**DART**

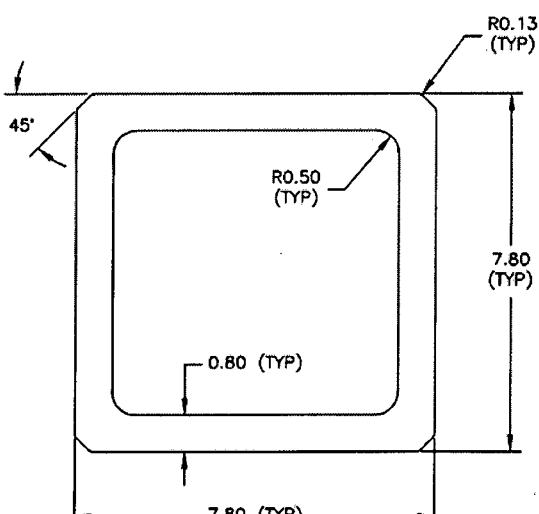
DESIGN RF	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3245	REV. A SHEET 5 OF 6
DATE 04.01.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

**RELEASED**04.04.21 *CH***D3245-043 DOOR ASSEMBLY****D3245-3 DOOR FLAT PATTERN**

MATERIAL: AISI 304/316 SS 0.032 THICK  
ANNEALED (REF. M304S22GA)

**D3245-043 NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS
- 6) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 7) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

**D3245-7 GASKET**

MATERIAL: DURABLA BLACK GASKET 0.035 THICK  
(PER. MIL-A-7021C OR MIL-A-17472B  
OR MIL-G-12803A)

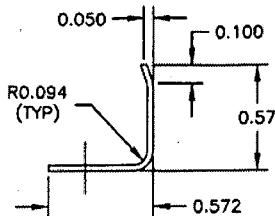
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WORK ORDER  
34607

**DART**O/COPY ISSUE  
O/COPY

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3245	SHEET 6 OF 6
DATE	TITLE	SCALE	
04.01.27	ACCESS PANEL ASSEMBLY	1:4	

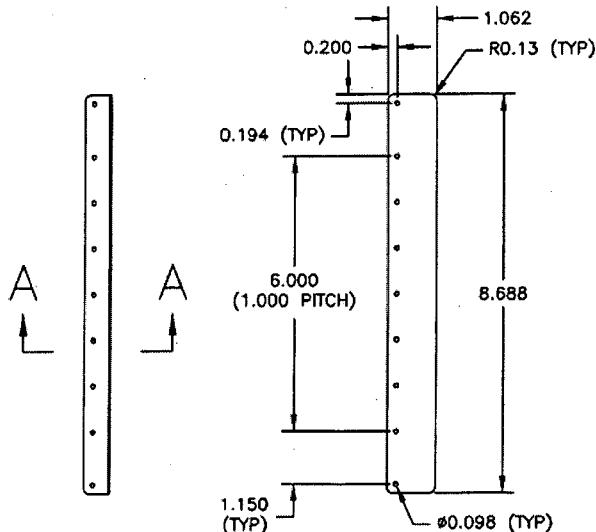
**RELEASED**

04-04-05

**D3245-5 BEND DETAIL**

VIEW A-A

SCALE 1:1

**D3245-5 FLAT PATTERN****D3245-5 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S2)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
NO. 34601

DART AEROSPACE LTD	Work Order:	34607
Description: PANEL	Part Number:	D3245-5
Inspection Dwg:	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>FB</u>	Audited by: <u>EN</u>	Prototype Approval: <u>n/a</u>
Date: <u>07-09-18</u>	Date: <u>07/09/18</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	